

## **APPENDIX**

To the Amendment dated March 16, 2007  
In reply to the Office Action of October 16, 2006  
issued in  
US APPLN SERIAL NO.: 10/783,866  
DOCKET: TFH063

- Chris Rauwendaal, *Polymer Extrusion*, Pg. 178  
Hanser Publishers 1994 (4 pages)

Chris Rauwendaal

# Polymer Extrusion



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Third, revised edition



Hanser Publishers, Munich Vienna New York

Hanser/Gardner Publications, Inc., Cincinnati

Distributed in the USA and in Canada by  
Hanser/Gardner Publications, Inc.  
6600 Clough Pike, Cincinnati, Ohio 45244-4090, USA  
Fax: +1 (513) 527-8950

Distributed in all other countries by  
Carl Hanser Verlag  
Postfach 860420, 81631 München, Germany  
Fax: +49 (89) 981264

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Library of Congress Cataloging-in-Publication Data

Rauwendaal, Chris.

Polymer extrusion / Chris Rauwendaal. -- 3rd. rev. ed.  
p. cm.

Includes bibliographical references and indexes.

ISBN 1-56990-140-6

1. Plastic--Extrusion. I. Title.

TP 1175.E9R37 1994

668.4'13--dc20

94-29397

Die Deutsche Bibliothek -- CIP-Einheitsaufnahme

**Rauwendaal, Chris:**

Polymer extrusion / Chris Rauwendaal. -- 3., rev. ed. -- Munich ;

Vienna ; New York : Hanser, 1994

ISBN 3-446-17960-7 (Munich...)

ISBN 1-56990-140-6 (New York)

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Printed in Germany by Druckerei Appi, Wemding

Plug flow generally does not happen in polymer melts, except in the case of wall slip (PVC). However, it does occur with granular polymeric solids. The solids conveying theory of single screw extruders is based on the assumption of plug flow of the solid polymer.

**SHEAR RATE ( $\dot{\gamma}$ ):** The difference in velocity per unit normal distance (normal to the direction of flow).

The rate of shearing or shear rate is one of the most important parameters in polymer melt processing. If the process is to be described quantitatively, the shear rate in the fluid at any location needs to be known. The shear rate is generally written with the Greek letter gamma,  $\dot{\gamma}$ , with the dot above the gamma indicating a time derivative ( $\dot{\gamma} = \frac{d\gamma}{dt}$ ). In terms of Figure 6-8, the shear rate can be written as:

$$\dot{\gamma}_{AB} \approx \frac{v_A - v_B}{AB} \quad (6-10)$$

Equation 6-10 is only valid for very small values of the normal distance AB. More accurately, the shear rate is:

$$\dot{\gamma}_{AB} = \lim_{AB \rightarrow 0} \frac{v_A - v_B}{AB} = \frac{dv(x)}{dy} \quad (6-11)$$

From equation 6-11, it can be seen that the local shear rate equals the local gradient of the velocity profile. Thus, if the velocity profile is known, the shear rate at any location can be determined.

**SHEAR STRAIN ( $\gamma$ ):** Displacement (in the direction of flow) per unit normal distance over a certain time period.

The shear strain is generally written with the Greek letter gamma ( $\gamma$ ), this time without the dot! The relationship between shear rate ( $\dot{\gamma}$ ) and shear strain ( $\gamma$ ) is:

$$\dot{\gamma} = \frac{d\gamma}{dt} \quad \text{and} \quad \gamma = \int \dot{\gamma} dt \quad (6-12)$$

In terms of Figure 6-8, the shear strain can be written as:

$$\gamma_{AB} = \frac{x_A - x_B}{AB} = \left. \frac{\Delta x}{\Delta y} \right|_{AB} = \tan \beta \quad (6-13)$$

The units of shear rate are  $\text{sec}^{-1}$  and the shear strain is a dimensionless number.

**SHEAR STRESS ( $\tau$ ):** The stress required to achieve a shearing type of deformation.

When a fluid is sheared, a certain force will be required to bring about that deformation. This force divided by the area over which it works is the shear stress. The shear stress is generally written with the Greek letter tau ( $\tau$ ). In a simple example, shown in Figure 6-10, the shear stress is:

Figure 6-10. Simple Shear Deformation.

$$\tau = \frac{F}{A}$$

and the shear rate is:

$$\dot{\gamma} = \frac{v}{\Delta y}$$

**SHEAR VISCOSITY ( $\eta$ ):**

$$\eta = \frac{\tau}{\dot{\gamma}}$$

The shear viscosity is generally defined as shear stress x time. The viscosity unit is the Poise. In order to determine the shear rate in a certain shear deformation, there are available to determine the shear rate.

**NEWTONIAN FLUID:**

Most low viscosity liquids are Newtonian. Therefore, Newtonian fluids have a constant viscosity versus shear rate, a Newtonian fluid.

A plot of shear stress versus shear rate for a Newtonian fluid is a straight line passing through the origin.

**NON-NEWTONIAN FLUID:**

High viscosity polymer melts are non-Newtonian. Their viscosity decreases with increasing shear rate.

Another type of non-Newtonian fluid is a pseudoplastic fluid. Its viscosity increases with increasing shear rate.

Figure 6-11. Flow Curves for a Newtonian Fluid, and a Pseudoplastic Fluid.